

Work Order ID 99891 -2
Friday, April 12, 2013 3:26:47 PM

Item ID: D4125-3

Revision ID:

Item Name: End

Start Date: 4/12/2013

Start Qty: 6.00

6

Required Date: 4/19/2013

Req'd Qty: 6.00

6

Reference:

Approvals: Process Plan: *MF*

Date: *13-4-12*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4125	C
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100	0.00
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100

Bandsaw

Jeaspa Bandsaw

Memo

I-Cut Blank at 6.500"

0.00

P0 13/04/25

10 P

105

105

HAAS 1

HAAS CNC vertical machine #1

Memo

Machined as per folio FB079

Rev: C

Dwg: C

Deburr

0.00

P0 13/04/27

*10 2
9*

PTO

Work Order: <u>99891 - 2</u>	DISPOSITION	IMPLEMENT/PROCESS	AGAINST DEPARTMENT/PROCESS	
Part No. <u>D4125-3</u>	Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier
NCR No. <u>13-2633</u>				Engineering Quality Other

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	12/04/21	105	1	Modified program manually, because required tool for the job broke, the modified program had one issue therefore 1 part was scrap. R.C. 1 and only tool break. SDU operators tries to make Due	DAS 16 05/04/21 13/04/20 13/04/20	Scrap + Destroy <i>228.44</i>	F.K. 19/04/21	SL 13-43	DAS 16 S-C. Q2LUT2 B14413.
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	Grain	Ovalized	Pressure/Forced
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
Cuffs	Contamination	Maintenance	Part Moved	
Heat Treat	Countersink	Mislabeled	Positioned Wrong	
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	
Ripples in Bend	Drill Holes	Offset		
Torque Waves in Extrusion	Drawing	Out of Calibration		
Turning Sequence	Finish	Out of Sequence		
Wave/Twist in Tube	Folio	Outside Dimensions		
				Other

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Item ID: D4125-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: End

Stop

NS2

Start Date: 4/12/2013 Start Qty: 6.00

6

Required Date: 4/19/2013 Req'd Qty: 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

12 13/04/27

10

2

9

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

9

SL 13-43

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

Memo

0.00

9 13-56

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Item ID: D4125-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: End

Start Date: 4/12/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/19/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

140

QC3-Inspect Part Finish

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC

Quality Control

Memo

0.00

9

Ø

DAS
19
9-89

13-05-09

150

Identify as per dwg & Stock Location: W4.003 0.00

150

Packaging

Packaging

Memo

0.00

9

Ø

M
13-05-09

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

13/5/15 ØØ

MF
13-5-13

Picklist Print

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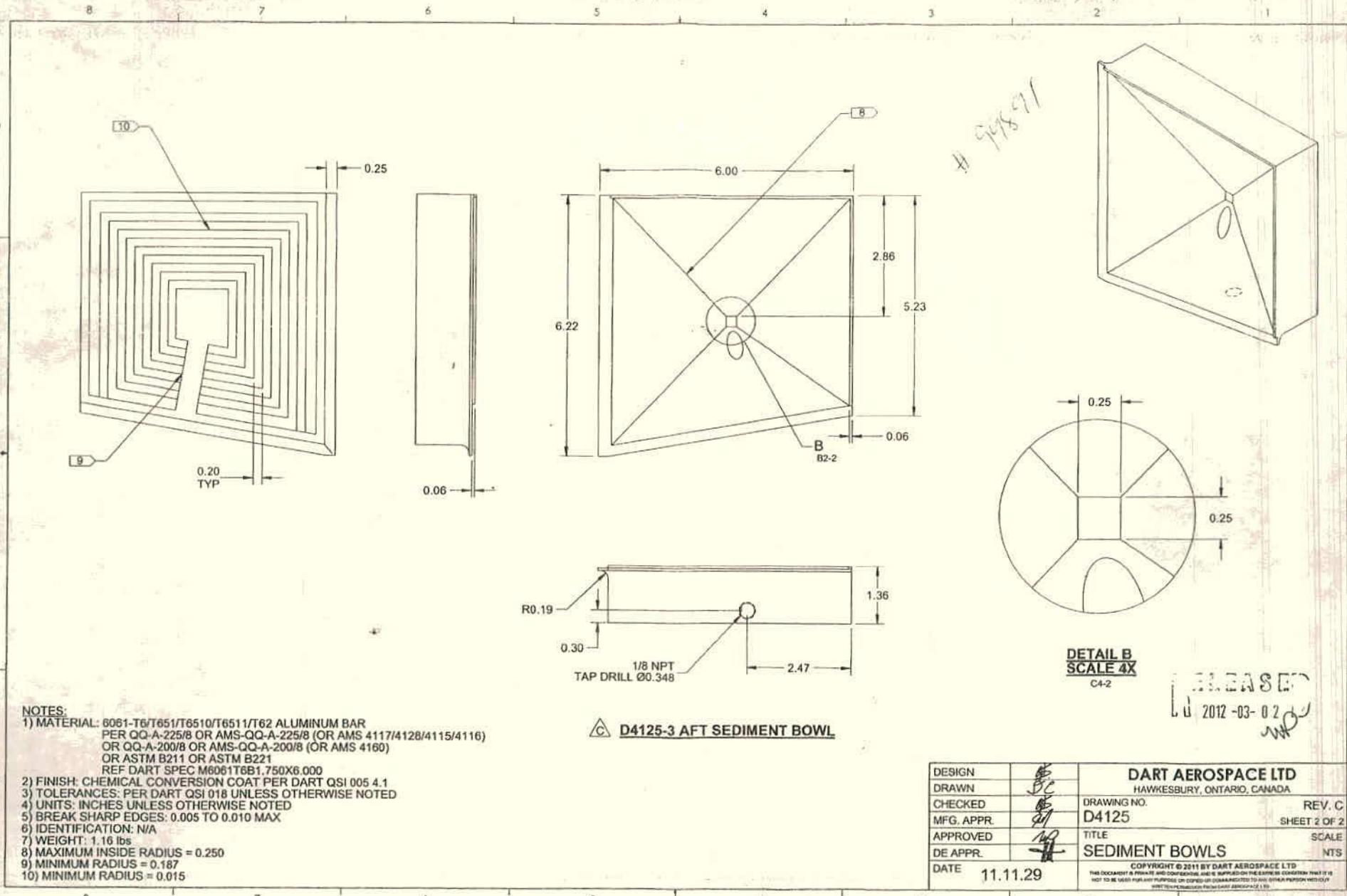
Work Order ID:	99891	Start Date:	4/12/2013	Required Date:	4/19/2013
Parent Item:	D4125-3	Start Qty:	6.00	Required Qty:	6.00
Parent Item Name:	End				
Comments:	IPP Rev:A 10.07.21 new issue DD verf:EC JFS verf:DD	IPP Rev:B 11/12/05 as per rev.B			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.000 6061-T6 BAR 2.00" X 8.00"		Purchased	No			100	f	4.7370	0.542	3.4231579			PD 13/04/25

Location	Loc Qty	Loc Code
MAT005	4.737	
123089	0.085	
124443	3.252	
125034	1.4	

→ 125386
12386

56
→ 57 FK: 13/04/28



DESIGN	<i>BC</i>	DART AEROSPACE LTD
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO. D4125 REV. C
MFG. APPR.	<i>BS</i>	SHEET 2 OF 2
APPROVED	<i>BC</i>	TITLE SEDIMENT BOWLS SCALE NTS
DE APPR.	<i>BC</i>	DATE 11.11.29

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DART AEROSPACE LTD	Work Order:	9758
Description: Aft Sediment Bowl	Part Number:	D4125-3
Inspection Dwg: D4125 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>F.K.</u>	Audited by: <u>X</u>	Preliminary Approval:
Date: <u>13/04/27</u>	Date: <u>B-43</u>	Date:

Rev	Date	Change	Revised by	Approved
A	12.07.31	New Issue	KJ	<i>[Signature]</i>